








11. 150 **Work Order ID 71840**

Wednesday, July 13, 2011 10:20:38 AM


Page 1

Item ID:	D2022-101	Accept		Setup	Start	
Revision ID:						
Item Name:	Spacer				Stop	
Start Date:	7/14/2011	Start Qty: 60.00		Cust Item ID:		
Required Date:	7/28/2011	Req'd Qty: 60.00		Customer:		
Reference:						

Approvals:	Process Plan:	<i>MF</i>	Date:	<i>11-07-13</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
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100		0.00							
									
Hardinge		0.00							

Hardinge CNC Lathe Small

Memo

Note: 257" dia drill
1-Turn as per folio 206 & dwg
FOLIO REV: *N/A*
DWG REV: *N/A*

2-Deburr as required

110		0.00							
									
QC		0.00							

Quality Control

Memo

11/8/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71840

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Item ID: D2022-101

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 7/14/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 60.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		R 11.8.15		60	6		
130 Packaging Packaging	Identify as per dwg & Stock Location: 304 Memo	0.00 0.00				11/8/10	60		
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00					11/8/18		

R11-08-14
60

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 71840

Parent Item: D2022-101

Parent Item Name: Spacer



Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP ☐ D02.03.07 ☐ Now made in house ☐ NG ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750 		Purchased	No			100	f	51.4830	0.03	1.8		5/11/8/13	
6061-T6 Round Bar .750"													

Location

Loc Qty

Loc Code

MAT013

51.483

112442

0.796

116406

0.617

117481

26.07

~~118106~~

24

1-8/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

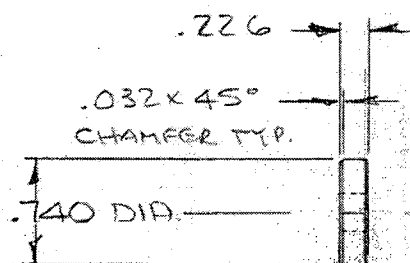
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
970119 BuJ



D2022-101
D2022-103

DRILL 'F' (.257) DIA. IN -101
DRILL 'P' (.323) DIA. IN -103

718410

MAT'L: ALUMINUM 6061-T6 (QQ-A-225/B)



2022

D2022-103	SPACER 5/16 ALUM 6061-T6	QQ-A-250/B
D2022-101	SPACER 1/4 ALUM 6061-T6	QQ-A-250/B

PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC/VENDOR
DART AERO ACCESSORIES INC				
CONTRACT NO.		DATE	CLIENT	
DESIGN		DATE	TITLE	
STRESS		CODE	REV.	
CHECKED		DATE NO.	SCALE	
CLIENT		DATE	SHT 1 OF 1	

REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS 523	QTY. REQUIRED	APPROVAL
DRAWN		BASIC CODE	QTY. DASH NO.	
APPROVED		QTY. DASH NO.	QTY. DASH NO.	
DESCRIPTION	REQUIREMENTS - UNLESS OTHERWISE SPECIFIED	QTY. DASH NO.	QTY. DASH NO.	
OF	GENERAL	QTY. DASH NO.	QTY. DASH NO.	
CHANGE	LIMITS	QTY. DASH NO.	QTY. DASH NO.	
	1. DIMENSIONS ARE IN INCHES 2. SPACER REQUIREMENTS 100% 3. REMOVE SHARP EDGES 0.13 MAX. 4. THREADS PER MIL. 2-7742 5. HOLER PER AND TOSBY	1. TOLERANCES - .001 & .002 2. ANGLES - .002 & .010 3. WALL THICKNESS - .002 & .010 4. RECTANGULARITY - .002 & .010 5. SYMMETRY ABOUT 6. HOLER PER AND TOSBY	QTY. DASH NO.	
REPORT ALL DISCREPANCIES - DO NOT SCALE				

